

# Work Order ID 90298

September-17-12 8:52:36 AM

\*90298\*

Page 1

Item ID: D4154-041 Accept \*N9000040100\* Setup Start \*NS1\*  
 Revision ID: Stop \*NS2\*  
 Item Name: Wearplate Assembly

Start Date: 9/17/12 Start Qty: 4.00 \*4\* 2 Cust Item ID:  
 Required Date: 10/05/12 Req'd Qty: 4.00 \*4\* Customer:

Reference:

Approvals: Process Plan: MLJ Date: 12-09-13 Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start \*NR1\*  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D4154	E								

100

0.00

\*100\*

Large Fab

Large Fab

## Memo

0.00

1- on D4155-1, fill cut outs with hardcoat welding rod as per dwg D4154

\*\*DT9756\*\*

2059 B Hardcoat Welding Rod

BATCH#: m/22910 → 20596

2-weld D4155-1 to wearplate by positioning holes together as per dwg D4154

304 S.S. Welding Rod

BATCH #: m/20013

3-Transfer drill holes in bar

4- Use DT9684 to check fit after welding

5- Cut extra material on back end of wearplate if necessary

(x2) ml 12-10-01

Chlorine

011-00110

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**\*90298\***

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Item ID: D4154-041 Accept **\*N900040100\*** Setup Start **\*NS1\***  
 Revision ID: Stop **\*NS2\***  
 Item Name: Wearplate Assembly  
 Start Date: 9/17/12 Start Qty: 4.00 **\*4\*** Cust Item ID:  
 Required Date: 10/05/12 Req'd Qty: 4.00 **\*4\*** Customer:  
 Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
110 <b>*110*</b> QC Quality Control	QC9- Inspect visual per QSI004- Fusion Welds  Memo	0.00 0.00	(DAS) 24 9-19	12-10-02	2x	X			
120 <b>*120*</b> QC Quality Control	QC5- Inspect part completeness to step on W/O  Memo	0.00 0.00	Smb 12-10-2	(DAS) 16 9-19 12/10/12	2				
150 <b>*150*</b> Small Fab Small Fab	Memo 1- After finish, coat entire top (concave) surface as per note 11 on sheet 2 of 3 dwg D4154. <b>B122669</b>	0.00 0.00			2	0	0	12-10-2	

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Item ID: D4154-041

Accept

**\*N900040100\***

Setup Start **\*NS1\***

Revision ID:

Item Name: Wearplate Assembly

Stop **\*NS2\***

Start Date: 9/17/12 Start Qty: 4.00

**\*4\***

Cust Item ID:

Required Date: 10/05/12 Req'd Qty: 4.00

**\*4\***

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start **\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop **\*NR2\***

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

160

QC5- Inspect part completeness to step on W/O

0.00

**\*160\***

QC

Memo

0.00

Quality Control

DAS  
16  
12/10/03

(x2)

170

Identify as per dwg & Stock Location: F21

0.00

**\*170\***

Packaging

Memo

0.00

Packaging

12 - 12/10/03

180

QC21- Final Inspection - Work Order Release

0.00

**\*180\***

QC

Memo

0.00

Quality Control

12/10/03

MR  
12-10-03



# Picklist Print

September-17-12 8:52:35 AM

Page 1

Work Order ID: 90298  
 Parent Item: D4154-041  
 Parent Item Name: Wearplate Assembly

Start Date: 9/17/12  
 Start Qty: 4.00

Required Date: 10/05/12  
 Required Qty: 4.00

Comments: IPP Rev:A 10.09.21 new issue DD verf:EC  
 DT9684 DD verf:EC IPP Rev:B 10.11.04 added  
 IPP Rev:C 11.04.14 as per dwg revB DD verf:EC  
 IPP Rev:D 12.09.14 as per dwg revE DD verf:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4154-1 Plate	B 90369	Manufactured	No			100	Each	0.0000	(x2)	4	ml	12-10-01	
D4155-1 Bar		Manufactured	No			100	Each	0.0000	(x2)	4	ml	12-10-01	

B 90366 x 2

ITEM NO.	QTY. -041	PART NUMBER	DESCRIPTION
1	X	D4154-041	WEARPLATE ASSEMBLY
2	1	D4154-1	PLATE
3	1	D4155-1	BAR
4	A/R	2059B	HARDCOAT, (SEE NOTE 9, SHT 2)
5	A/R	4714	(SEE NOTE 11, SHT2)

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WITHOUT NOTICE  
WORK ORDER

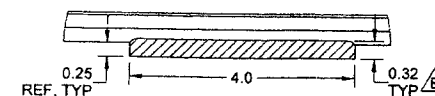
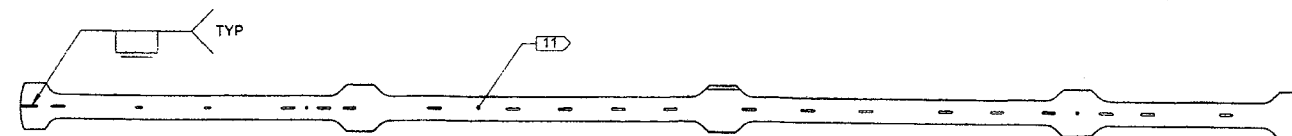
NO. 90298 MLJ  
12-09-17

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R 2012-09-04  
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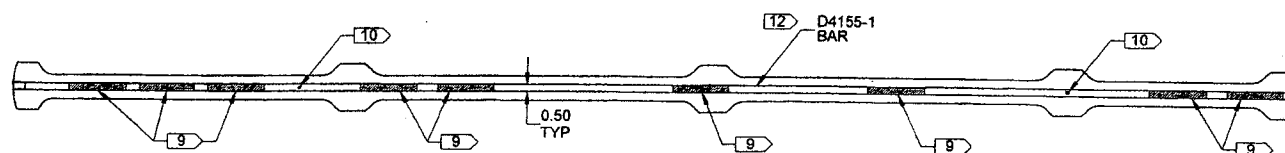
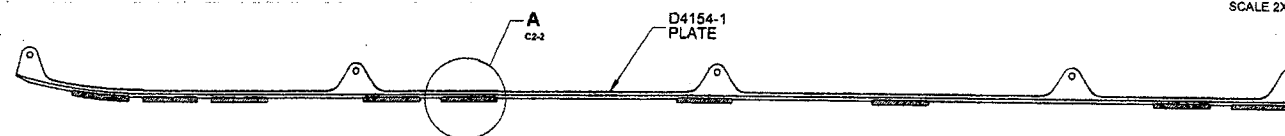
# **D4154-041 WEARPLATE ASSEMBLY**

E	SHT 3 SLOTS RE-PITCHED (PAR 12-213); 0.32 WAS 0.37	AJS	12.08.07
D	70.45 WAS 74.45 & Ø0.188 HOLES NOW 2 PL (ZN C4-3 & C7-3)	RF	12.05.03
C	REVISE NOTE 9 (ZN A8-2); ADD HARDCOAT (ZN B7-2); ADD DETAIL A (ZN C2-2)	RF	12.02.21
B	ITEM 4 WAS PR1422 (D3-1); REMOVED FINISH TO NOTE 2 (A8-2); REMOVED SECTION A-A (NO LONGER REQUIRED); REVISED D4154-1F	MB	11.04.05
A	NEW ISSUE	SC	10.07.22
REV.	DESCRIPTION	BY	DATE
DESIGN	SC	<b>DART AEROSPACE USA, INC.</b> KENT, VA	
DRAWN	AJS		
CHECKED	RP	DRAWING NO.	REV. E
MFG. APPR.	N	D4154	SHEET 1 OF 4
APPROVED	149	TITLE	SCALE
DE APPR.	#	WEARPLATE ASSEMBLY	NTS
DATE	12.08.07	<small>COPYRIGHT © 2010 BY DART AEROSPACE USA, INC.</small> <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSES OR COMMERCE TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	

90298



**DETAIL A**  
TYP  
SCALE 2X



**D4154-041 WEARPLATE ASSEMBLY**

**NOTES:**

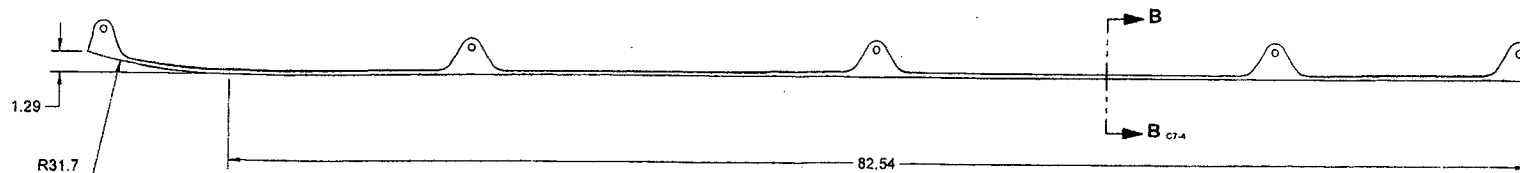
- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 7.75 lbs
- 8) WELDING: PER QSI 004
- 9) 2059B HARDCOAT WELD, 0.32 THICK x 0.50 WIDE, FLUSH WITH D4155-1 BAR ON LATERAL SURFACES, 9 PL  $\Delta$
- 10) TRANSFER DRILL  $\phi 0.188$  HOLES FROM D4154-1 PLATE TO D4155-1 BAR
- 11) COAT ENTIRE TOP (CONCAVE) SURFACE WITH A LAYER OF PLUS ONE ROCKGUARD 4714, 0.020-0.040 THICK
- 12) FORM TO MATCH PROFILE OF D4154-1 AT TIME OF WELDING

RELEASED  
2012-09-04

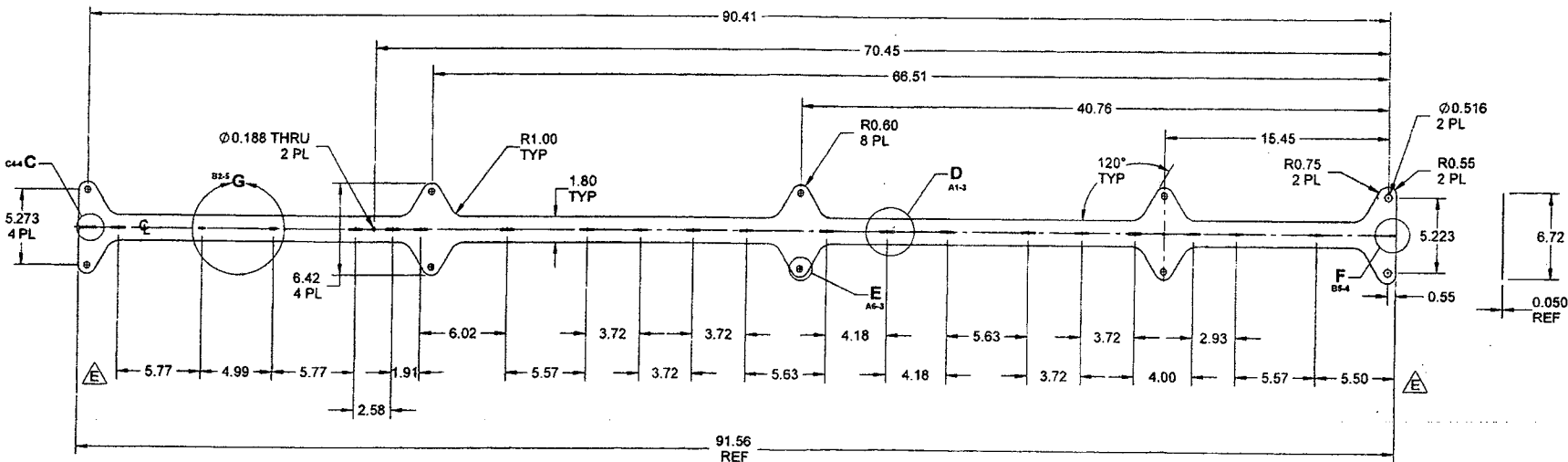
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**D4154-1 PLATE**  
(MAKE FROM D4154-1F)



**D4154-1F FLAT PATTERN**

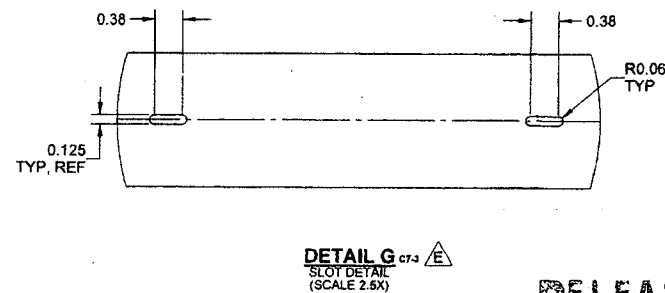
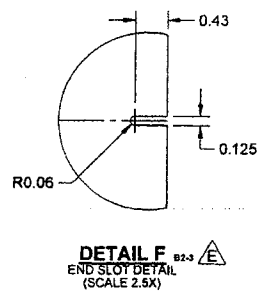
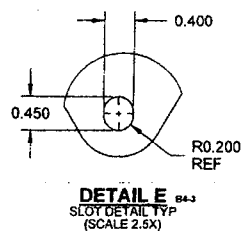
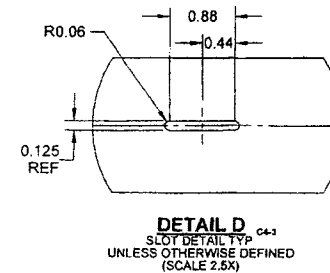
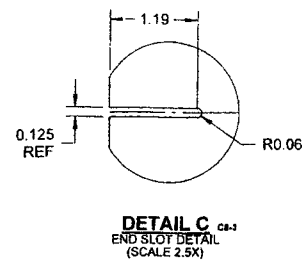
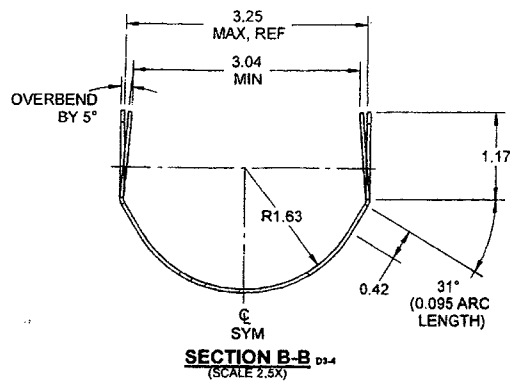
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2012-09-04  
MD

**NOTES:**

- 1) MATERIAL : AISI 304/316 STAINLESS STEEL PER AMS 5513 OR 5524  
OR ASTM A240 OR ASME SA240  
18 GAUGE 0.050 THICK, (REF. DART SPEC. M304S18GA)
- 2) FINISH : NONE
- 3) TOLERANCES : PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS : INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES : 0.005 TO 0.010 MAX
- 6) IDENTIFICATION : NONE
- 7) WEIGHT : 2.95 lbs

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MFG. APPR.	<i>[Signature]</i>	D4154	SHEET 3 OF 4
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	WEARPLATE ASSEMBLY	NTS
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